

Split

Need to ship

*Oct. 24 **

75207

Page 1

Work Order ID 75207-1

October-18-11 4:11:27 PM

Item ID: D3199-4

Revision ID:

Item Name: Bracket, Fwd RH

Start Date: 18/10/2011 **Start Qty:** 90.00

Accept

N900040100

Setup Start

NS1

Required Date: 04/11/2011 **Req'd Qty:** 90.00

90

Cust Item ID:

Stop

NS2

90

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/10/18 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--	----------------------------------	------------------------------	----------------	---------------	----------------------	-----------------------	-----------------------	--------------------------	------------------------

Draw Nbr	Revision Nbr
-----------------	---------------------

D3199	E
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100		0.00
-----	--	------

100	FLOW WATER JET	
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Waterjet	Memo	0.00
----------	------	------

FLOW CNC Waterjet	Cut as per Dwg D3199	
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Dwg Rev: F

Prog Rev: F

Deburr if required

B11-10-19

(136)

110	QC2- Inspect parts off machine FAI/FAIB	0.00
-----	---	------

110		
--------------	--	--

QC	Memo	0.00
----	------	------

Quality Control		
-----------------	--	--

B11-10-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75207

October-18-11 4:11:27 PM

75207

Page 2

Item ID: D3199-4

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket, Fwd RH

Stop

NS2

Start Date: 18/10/2011 Start Qty: 90.00

90

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 90.00

90

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

120

120

QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Sun 10/25

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

counts

x136

Qspurit

130

130

Brake NC

Brake NC

Bend as per dwg
Small Fab

Memo

0.00

Sa 11/10/25

0.00

90

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

Sun 10/25

0.00

counts
x90

Da 10/19

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 75207

October-18-11 4:11:27 PM

75207

Page 3

Item ID: D3199-4

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket, Fwd RH

Stop

NS2

Start Date: 18/10/2011 Start Qty: 90.00

90

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 90.00

90

Customer:

Reference:

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

150

Powdercoat

Powder Coating

Memo

1:40 320°F
2:10

90X8M-F 11/10/26

160

QC3- Inspect Part Finish

0.00

160

QC

Quality Control

Memo

0.00

90-BL 11-10-26

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Packaging

Memo

0.00

11/10/26 928

W/O:		WORK ORDER CHANGES					
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Page 4

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N900040100

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NS1

Revision ID:

Item Name: Bracket, Fwd RH

Stop

NS2

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Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 90.00

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Quality Control

Memo

0.00

11/10/26 JF

MF
11-10-26

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NOTE: Date & initial all entries

Picklist Print

October-18-11 4:11:32 PM

Page 1

Work Order ID: 75207

75207
D3199-4

Parent Item: D3199-4

Parent Item Name: Bracket, Fwd RH

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 90.00

Required Qty: 90.00

Comments: IPP RevA: RevC-prelim DD verified by:EC
11.03.31 as per ecn 11-531 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	137.0795	0.1673	15.84947	23.		

M304S20GA

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT020	137.0795	
116623	0.2	
117550	8.363	
117933	43.3442	
118400	25.6723	
118964	59.5	

(136)

(136)

W/O:		WORK ORDER CHANGES					
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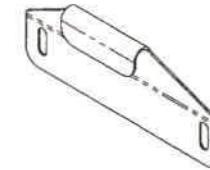
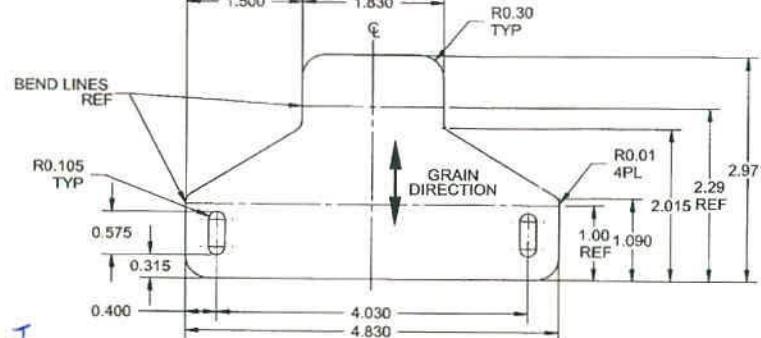
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 75207 ML.J
11/10/18



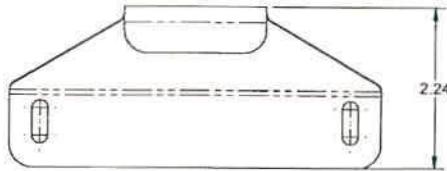
D3199-1F FLAT PATTERN

C

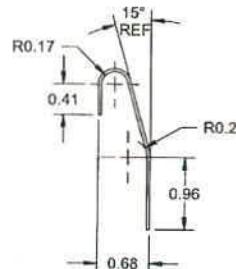
D

B

C



D3199-1 BRACKET
MADE FROM D3199-1F



RELEASED
2011-07-18
MP

E	RE-DESIGNED D3199-3/4-3F PER CUSTOMER FEEDBACK TO OPTIMIZE FIT.	MB	11.07.11
D	RE-DESIGNED D3199-3/4-3F PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF.: PAR11-79	MB	11.03.21
C	ADD 3/4 PART (SHEET 2-4)	HS	09.11.19
B	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	CB	08.11.01
A	NEW ISSUE	CP	03.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>DP</i>	DART AEROSPACE LTD	
DRAWN	<i>1</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AP</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>MP</i>	D3199	SHEET 1 OF 4
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	BRACKET	NTS
DATE	11.07.11	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT APPROVAL FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

A

A

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-X" AND B/N "XXXXX" PER QSI 044 6.1
- 7) WEIGHT: D3199-1 = 0.11 lbs, D3199-3/4 = 0.26 lbs EACH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

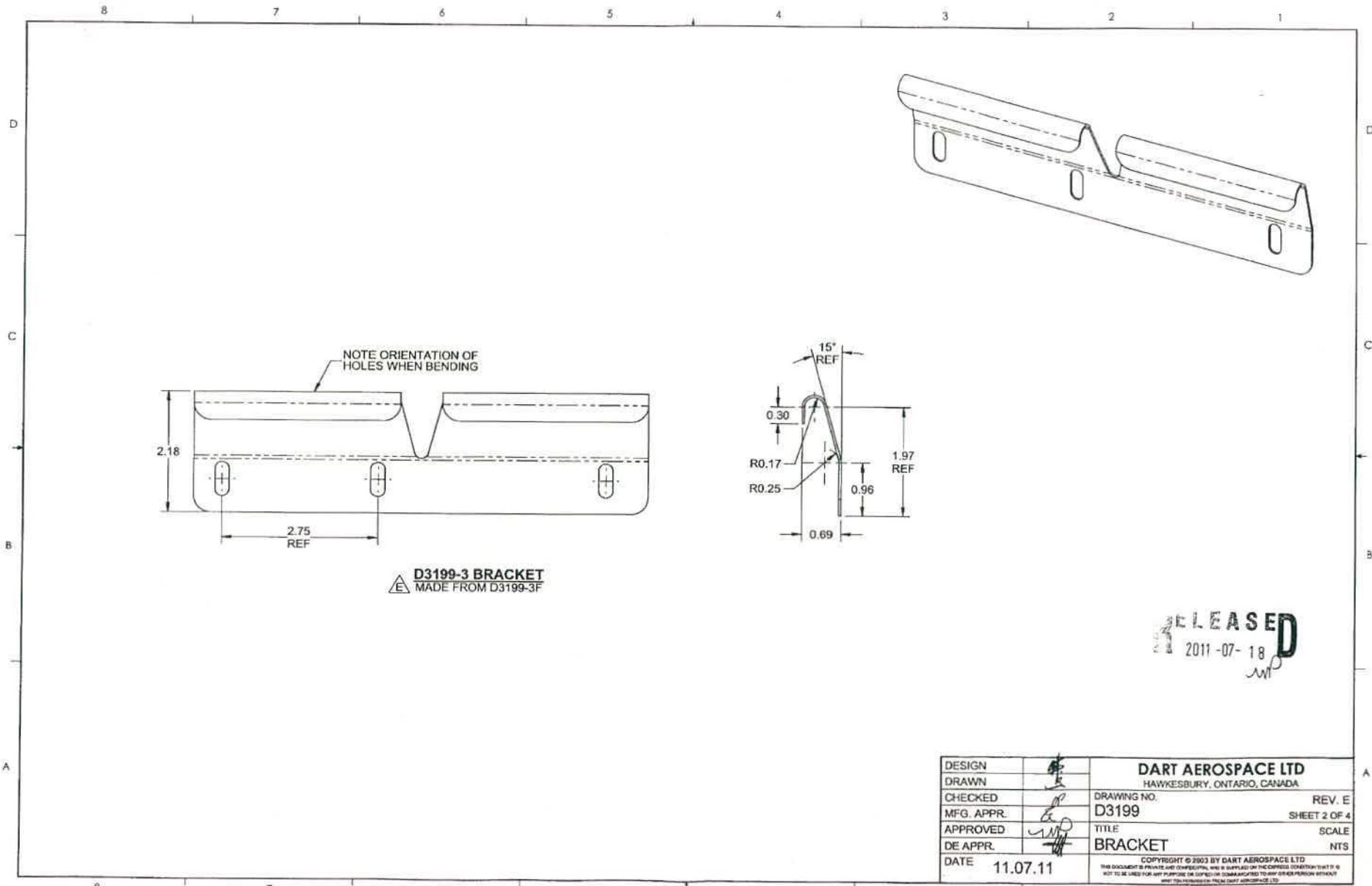
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75207



RELEASED
2011-07-18
MP

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. E
MFG. APPR.		D3199 SHEET 2 OF 4
APPROVED		TITLE
DE APPR.		SCALE
		NTS
DATE	11.07.11	

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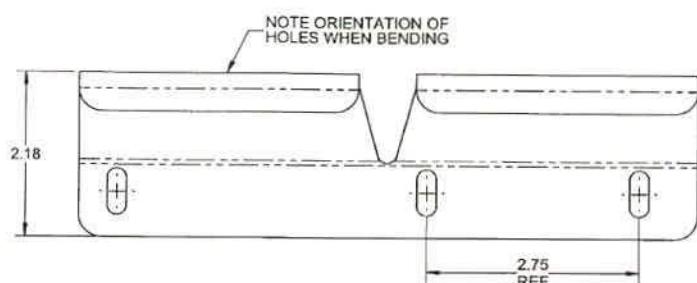
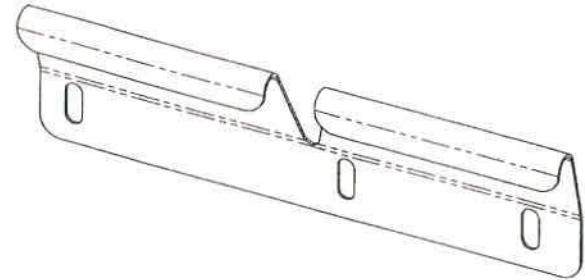
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

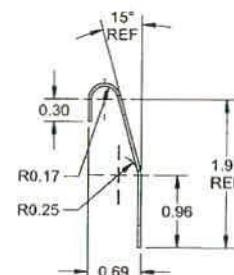
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75207



D3199-4 BRACKET
MADE FROM D3199-3F



RELEASED
2011-07-18
MM

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	REV. E
APPROVED	<i>[Signature]</i>	D3199
DE APPR.	<i>[Signature]</i>	SHEET 3 OF 4
DATE	11.07.11	TITLE
		SCALE
		NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

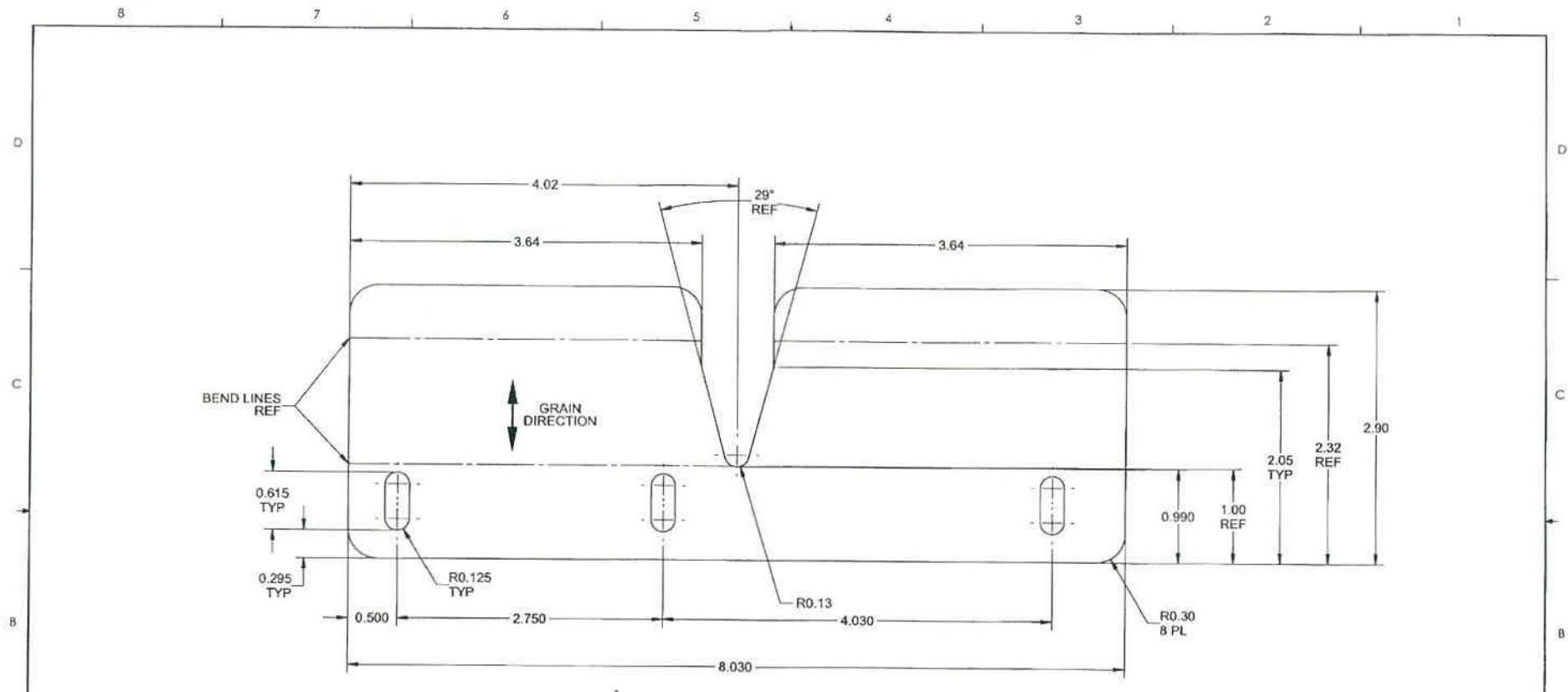
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RELEASED
2011-07-18
WJ

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PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.25 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. E
MFG. APPR.	<i>[Signature]</i>	D3199 SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	BRACKET NTS
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NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order:

7520
~~2016~~

Description: BLACK

Part Number: D31G4-3

Inspection Dwg: 7399-2 Rev:

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

۲۳

First Article

X

Prototype

Measured by:

Audited by:

Prototype Approval:

Date: _____

1

Date:

3

Water

11

Date: 11-10-19

Date: 11/20/25

Revised by Approved
KJ/JLM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

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